

Tuesday, July 25, 2017 7:54:33 AM

Page 1

Run	Start	*NR1*
	Stop	*NR2*
1	100	100
2	100	100
3	100	100
4	100	100
5	100	100
6	100	100
7	100	100
8	100	100
9	100	100
10	100	100
11	100	100
12	100	100
13	100	100
14	100	100
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18	100	100
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21	100	100
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37	100	100
38	100	100
39	100	100
40	100	100
41	100	100
42	100	100
43	100	100
44	100	100
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46	100	100
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85	100	100
86	100	100
87	100	100
88	100	100
89	100	100
90	100	100
91	100	100
92	100	100
93	100	100
94	100	100
95	100	100
96	100	100
97	100	100
98	100	100
99	100	100
100	100	100

[illegible]

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Page 2

Item ID: D3220-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler Assembly
Start Date: 7/25/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 36 9-89
130 *130* Small Fab	Small Fab	0.00				4x			17/07/31	
Small Fab	Memo 1-Deburr 2-C'sink D3220-1 as per Dwg D3220	0.29								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				4				DAS 38 9-89 AUG 01 2017
Quality Control	Memo	0.08								
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00								
Hand Finishing	Memo	0.33								(x4) 2017/08/02 BEB.

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Page 3

Item ID: D3220-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler Assembly
Start Date: 7/25/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00				4x			17/08/03
Quality Control									DAS 36 9:89
170		0.00							
170	Small Fab								
Small Fab	Memo	0.33				4x			17/08/03
Small Fab	Assemble D3220-041 doubler as per Dwg D3220								DAS 36 9:89
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.08				4			17/08/03
Quality Control									DAS 38 9:89 AUG 04 2017

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Page 4

Item ID: D3220-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler Assembly
Start Date: 7/25/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>ST485</u>	0.00							
190									
Packaging	Memo	0.04			DAS 26 9-89	4		AUG 04 2017	<i>val</i>
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.40							17/8/948
Quality Control									

(Signature)
AUG 04 2017

Picklist Print

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Work Order ID: 164619

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Parent Item: D3220-041

D3220-041

Parent Item Name: Doubler Assembly

Start Date: 7/25/2017

Required Date: 8/4/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased		No		100	sf	137.0900	0.6926	2.916210			DAS
M2024T3S 050									**			17/07/28	40
2024-T3 .050 sheet													9-86

Location	Loc Qty	Loc Code
MAT022	137.09	
m134581	9.39	
m137626	95.4	
m137762	32.3	

MS20426AD3-3	Purchased	No			170	Each	2,047.000	8					
MS20426AD3-3									**			17/08/03	DAS
RIVET													36
													9-89

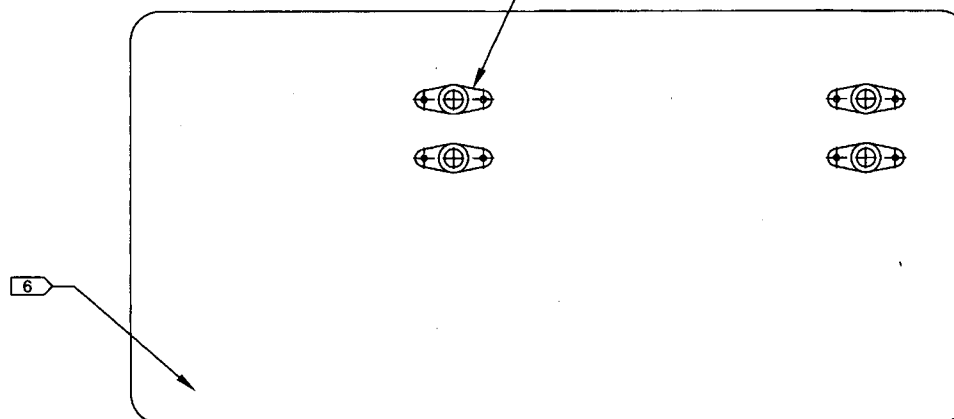
Location	Loc Qty	Loc Code
FG107/108	80	
M137350	80	
fg108	200	
M134946	200	
ST312	1767	
M135274	1767	

MS21059L4	Purchased	No			170	Each	57.0000	4					
MS21059L 4									**			17/08/03	DAS
Nutplate													36
													9-89

Location	Loc Qty	Loc Code
ST301	57	
m137178	4	
m137320	3	
m137736	50	

Item	Qty -041	Qty -042	Part Number	Description
1	X		D3220-041	DOUBLER ASSEMBLY
2		X	D3220-042	DOUBLER ASSEMBLY
3	1		D3220-1	DOUBLER
4		1	D3220-2	DOUBLER
5	4	4	MS21059L4	NUTPLATE
6	8	8	MS20426AD3-3	RIVET

B
MS21059L4 NUTPLATE
MS20426AD3-3 RIVET, 2X
4 PL



D3220-1/2 DOUBLER

**D3220-041 DOUBLER ASSEMBLY (SHOWN WITH D3220-1 DOUBLER)
D3220-042 (OPPOSITE)**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK COPY

NO. 164619 MJS
1207-25

RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3220-041 = 0.53 lbs
D3220-042 = 0.53 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. Ø0.316 WAS Ø0.323 (ZN C8-2, B4-3); MS20426AD3-3 WAS MS20426AD3-4 (ZN D4-1); CORRECT TYPO NOTE 1 (ZN A8-2, A8-3); REF PAR 09-025	RF	09.07.08
A	NEW ISSUE	CP	03.10.16
REV	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3220	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DOUBLER	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

D

Ø0.098
CSK Ø0.180x100°
NEAR SIDE, 8 PL

B
Ø0.316
TYP, 4 PL

GRAIN
DIRECTION

0.500 TYP

1.000 TYP

R0.50
TYP

B1-2
SEE DETAIL A
TYP

100°
REF

0.050
REF

DETAIL A
SCALE 5X

D3220-1 DOUBLER

RELEASED
2009-09-09

B

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3220	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

A